

Date: Friday, 02/05/2008 10:47:52 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HEAD REST
Job Number :	38999		
Estimate Number :	10423		
P.O. Number :		Part Number :	D33033
This Issue :	02/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3303 REV. B
First issue :	/ /	Project Number :	N/A
Previous Run :	38972	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	<u>JUL 08.5.02</u>	Due Date :	10/05/2008
Comment :	Est:A 04.09.07 New issue KJ/JLM	Qty:	10 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------



3.7



Comment: Qty.: 0.3135 sf(s)/Unit Total: 3.1353 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch: 107572

B 8-5-7

(10)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



$$\frac{B}{B}$$

B 8-5-7



Comment: FLOW WATER JET

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



B 8-5-7



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

508/05/02

(x10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



PD →

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

B 8-5-7

2- C'sink nut plate holes as per Dwg D3303

3-polish waterjet marks

508/07/24 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3303-3 PAR #: _____ Fault Category: Prod / Ins. Ass. ^{not \$ Small} NCR: Yes No DQA: D Date: 08/07/09
D3303-043 QA: N/C Closed: D Date: 08/07/09

NCR: <u>38999</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/07/09</u>		During inspection of counter C-Sink holes two (2) parts were found to have two two C-Sink's underfired	<u>ASUMH</u>	Scrap and Destroy and No Replac Qty <u>(2)</u>	<u>ED</u> <u>08/07/09</u>	<u>S</u> <u>08/07/09</u>	<u>ASUMH</u>	<u>6</u> <u>08/07/09</u>
		L.L. employee counter sink the hole too deep						

NOTE: Date & initial all entries

Date: Friday, 02/05/2008 10:47:52 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAD REST

Job Number: 38999

Part Number: D33033

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3303

To fit de 9011

SB 08/07/24

X8

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/24

X8

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

R12 / FL

08/07/23

8X

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

B/L 08-07-28

8

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5/188

P 08/07/28

8

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/29

Job Completion



MF 08-07-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 38999
Description: Head Rest		Part Number: D3303-3
Inspection Dwg: D3303	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

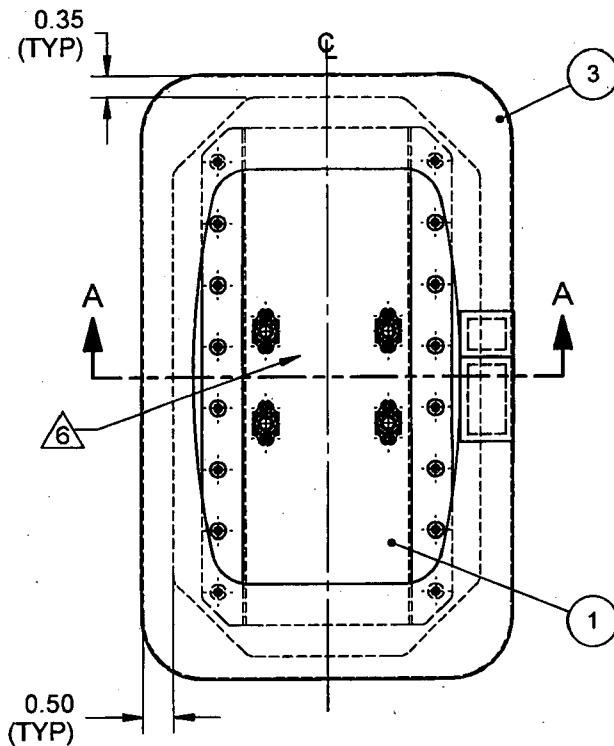
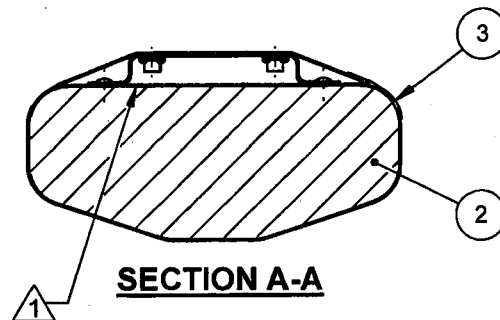
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.741	+/-0.010	4.853	*			
4.221	+/-0.005	4.333	*			
0.550	+/-0.010	.549	*			
0.260	+/-0.010	.261	*			
3.300	+/-0.010	3.300	*			
1.500	+/-0.005	1.498	*			
0.250	+/-0.005	.250	*			
Ø0.219	+0.005/-0.000	.222	*			
Ø0.098	+0.005/-0.000	.099	*			
Ø0.128	+0.005/-0.000	.130	*			
R0.12	+/-0.030	.12	*			
2.000	+/-0.005	1.999	*			
1.371	+/-0.010	1.425	*			
0.44 x 45°	+/-0.030	.44	*			
8.100	+/-0.010	8.100	*			
7.000	+/-0.005	6.997	*			
1.000	+/-0.005	1.000	*			
0.040	+/-0.010	.039	*			

Measured by: IB	Audited by: [Signature]	Prototype Approval: N/A
Date: 8-5-7	Date: 08/05/07	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.09.08	New Issue	KJ/JLM	[Signature]

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 1 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:3
REV	DATE	DESCRIPTION	
A	04.08.18	NEW ISSUE	
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE	

**RELEASED***cc 09.19***D3303-041 HEAD REST**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

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WORK ORDER
NO. *38999*

NOTES:

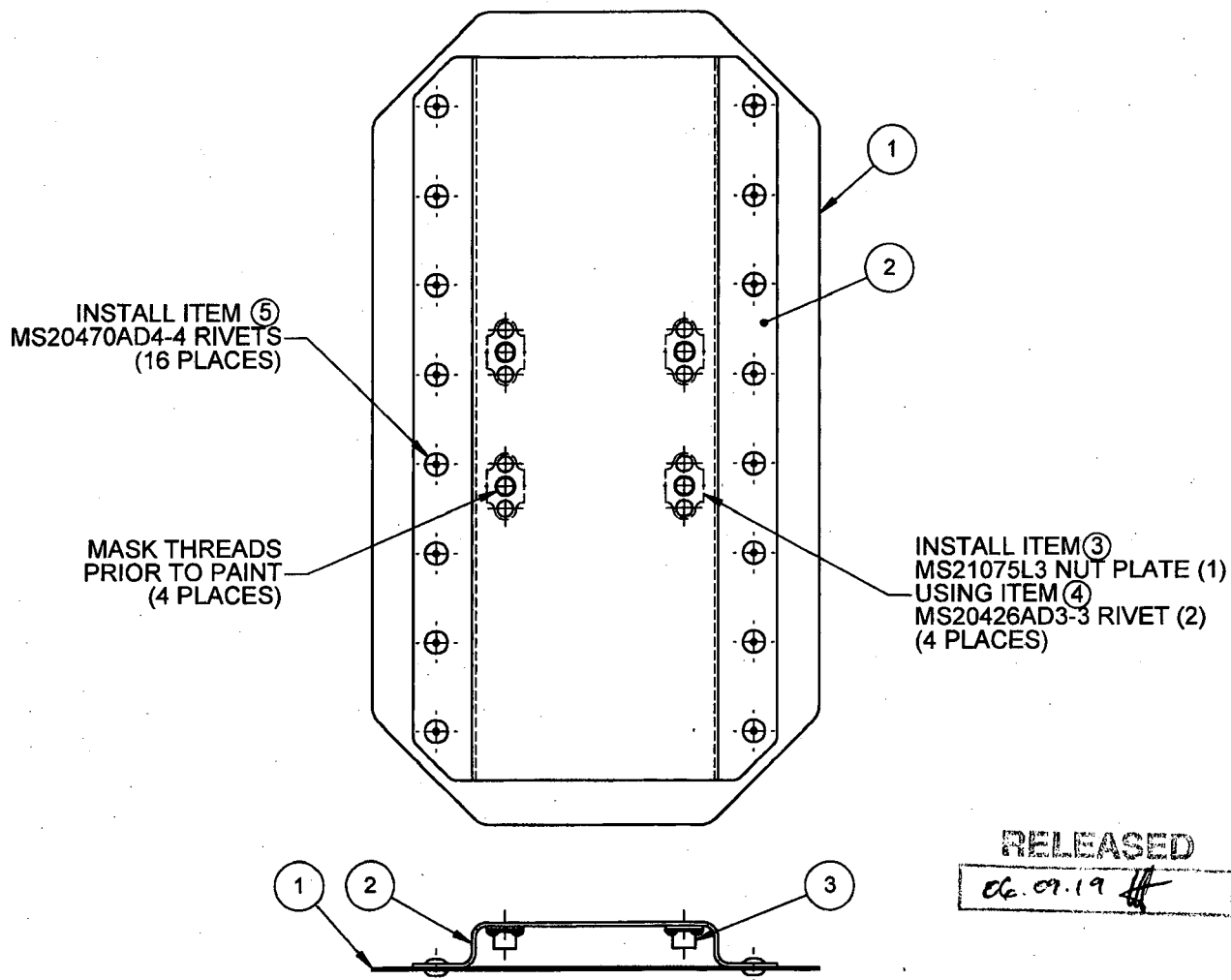
- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 2 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



RELEASED
06.09.19 *[Signature]*

D3303-043 BRACKET ASSEMBLY

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

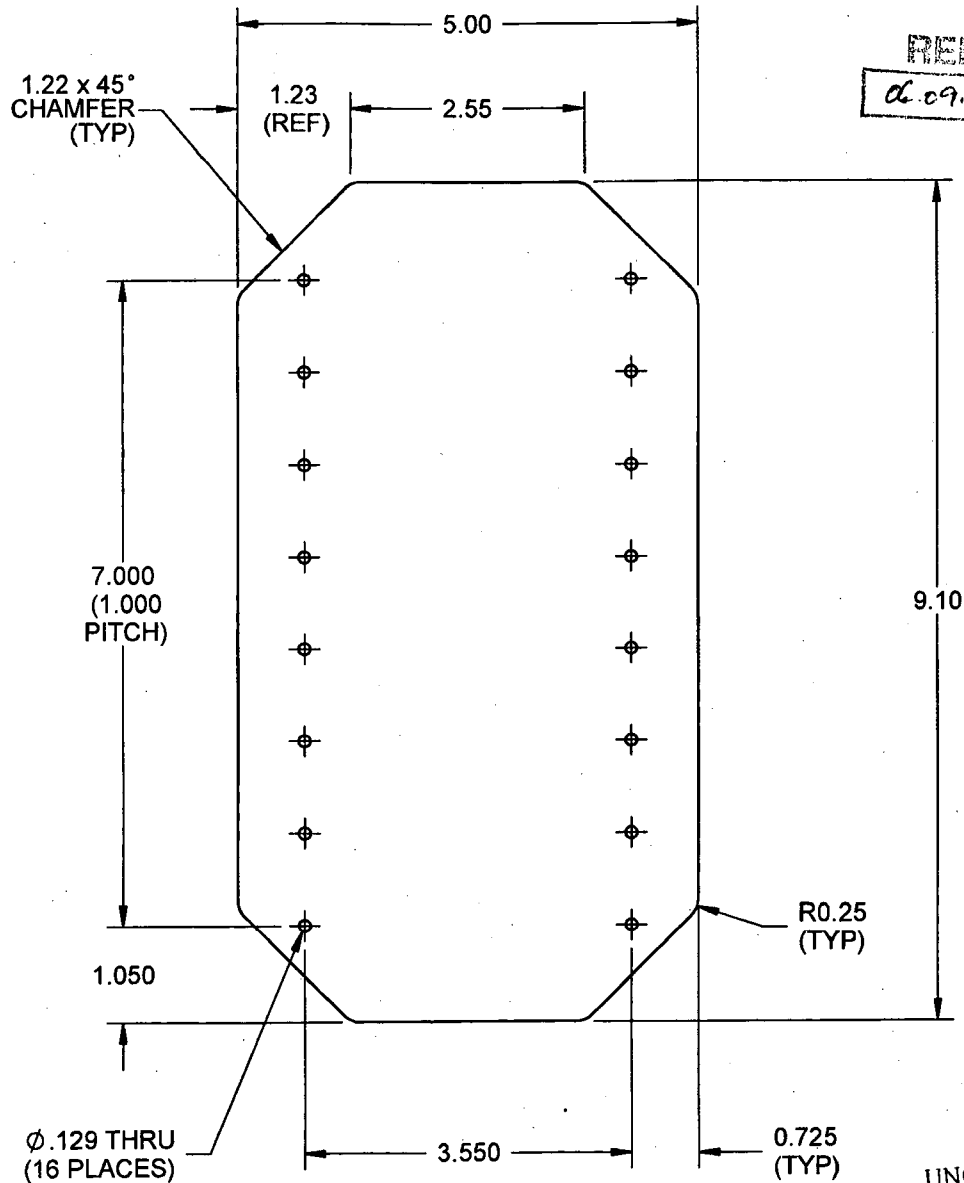
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DATE 06.08.17		TITLE HEAD REST	SCALE 1:2

**D3303-1 PLATE****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

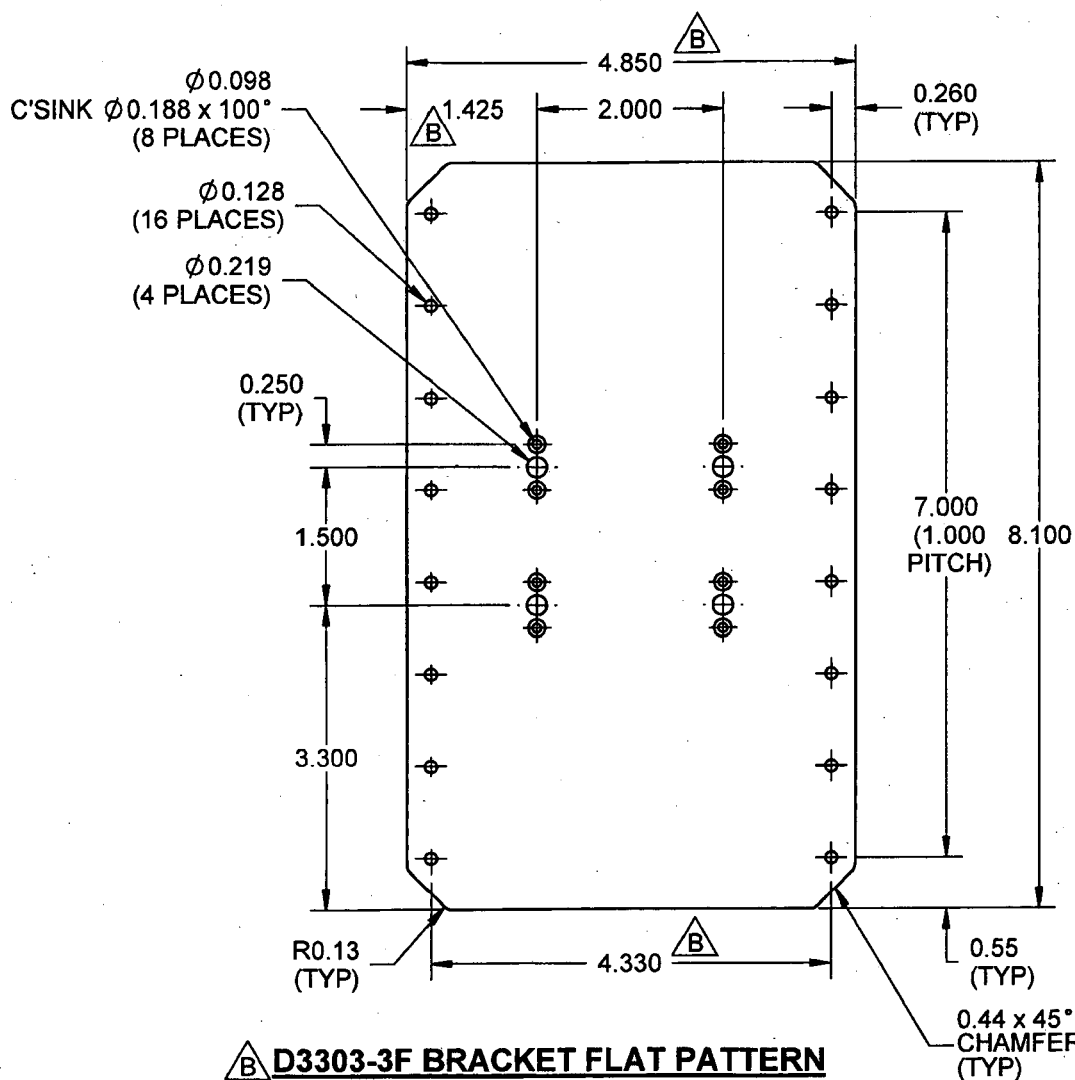
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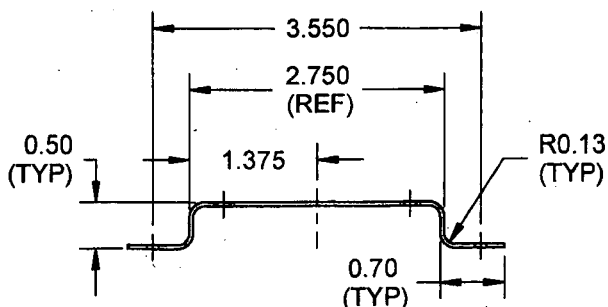
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 4 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



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06-09-19

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**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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